



Dart Aerospace Ltd.
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RBW6510G04631-6F-1
Job Sheet 199035



Part No: RBW6510G04631-6F-1

Job Qty: 2 pcs

Part Name: Reaction Weldment Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/9/19

Job Tracking No:

Due Date: 10/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6510G04631-6F Rev A IPP Rev. A 19.08.08 New issue DP Verify DD

Ship Via:

Bill of Materials



Container No: S236752



Part: RBW6510G04631-6F-1

Job No: 199035

Serial No/Batch: S236752

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Date: 12/03/19

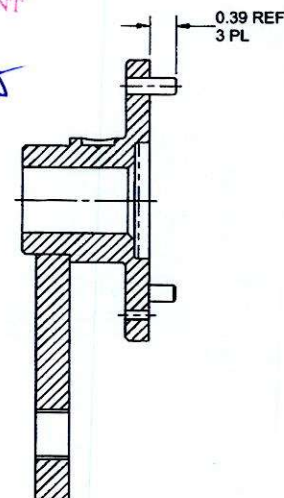
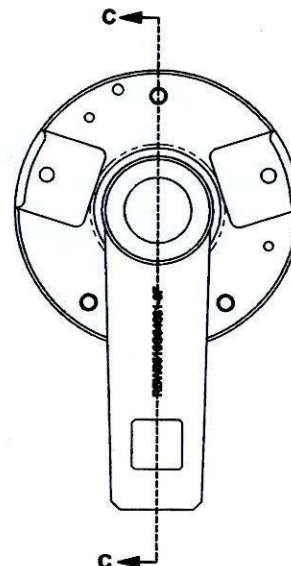
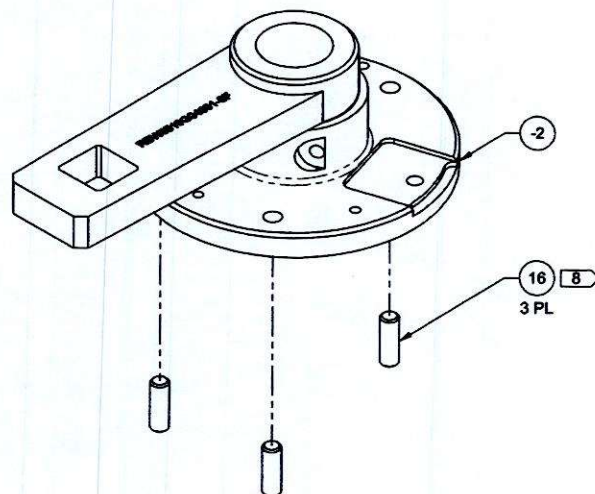
Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	10/21/19	0.00	0.40	Small Fab - 1		MLL	
						Small Fab - 2			
						Small Fab - 3			
						Small Fab - 4			
						Small Fab - 5			
						Small Fab - 6			
						Small Fab - 7			
						Small Fab - 8			
110	QC 5	2 pcs	10/21/19	0.00	0.00	QC 5 - 10		DAS DEC 03 2019 40 9:00	
						QC 5 - 12			
						QC 5 - 17			
						QC 5 - 18			
						QC 5 - 19			
						QC 5 - 22			
						QC 5 - 24			
						QC 5 - 3			
						QC 5 - 43			
						QC 5 - 49			
						QC 5 - 51			
						QC 5 - 58			
						QC 5 - 68			
						QC 5 - 9			
						QC 5 - 50			
						QC 5 - 30			
						QC 5 - 40			
						120	Packaging 3-1 - Stock - B4B		2 pcs
Packaging 3 - 2 - B4B									
Packaging 3 - 3 - B4B									
Packaging 3 - 4 - B4B									
Packaging 3 - 5 - B4B									
Packaging 3 - 6 - B4B									
Packaging 3 - 7 - B4B									
Packaging 3 - 8 - B4B									
Packaging 3 - 9 - B4B									
Packaging 3 - 10 - B4B									
130	QC 21 - SA	2 pcs	10/21/19	0.00	0.00	QC 21 - SA - 21		DAS 21 9:00 DEC 04 2019	
						QC 21 - SA - 70			
						QC 21 - SA - 53			
Part Op 100 - Assemble as per DWG. See note 8. Descriptions: 110 - QC5- Inspect part completeness to step on W/O 120 - Identify as per dwg & Stock Location: 130 - QC21- Final Inspection - Work Order Release									

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
98381A328	Black Oxide Steel Dowel Pin 1/4" Dia. X 3/4" Long	6 Ea (3 ea)	100-Small Fab - 1	5306440
RBW6510G04631-6F-2	Reaction Weldment	2 pcs (1 ea)	100-Small Fab - 1	5229925

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	98381A328	6	0	0
	RBW6510G04631-6F-2	2	0	0
Part Specifications				
Specifications could not be found.				

Plex 8/9/19 2:02 PM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6510G04631-6F-2	REACTION WELDMENT
16	3	McMaster#98381A328 OR EQUIV.	BLACK OXIDE STEEL DOWEL PIN 1/4" DIA. X 3/4" LG.



SECTION C-C

RBW6510G04631-6F-1 REACTION WELDMENT ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 199035
MLJ
19-08-09

- NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN
8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 16 FLUSH WITH ITEM -2, AND REMOVE EXCESS

DESIGN DRAWN	KPT	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	VM	RBW6510G04631-6F	SHEET 3 OF 10
APPROVED	FK	TITLE	SCALE
		REACTION ASSEMBLY	NTS
DATE	2019-07-09	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					